

Date: Tuesday, 16/12/2008 2:13:17 PM  
 User: Julie Dawson

Split

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAFFLE ASSEMBLY
Job Number : 44125-2	
Estimate Number : 11265	
P.O. Number :	Part Number : D3276042
This Issue : 16/12/2008 S.O. No. :	Drawing Number : D3276 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 36597	Material :
Written By :	Due Date : 30/12/2008 Qty: 11 Um: Each
Checked & Approved By : <u>JLD 16-12-08</u>	
Comment : Est Rev:A New Issue 05-12-06 JLM	
Est Rev:B Now on Waterjet 06-09-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick  
 (M6061T6S.040)  
 Batch: 109396 1B 8-12-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3276  
 Dwg Rev: B 1B 8-12-17  
 Prog Rev: B

2-Deburr if necessary 1B 8-12-17



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/12/17 (H2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

N/A S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 44125

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Roll as per Dwg D3276

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40  
320.0F  
12:10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s)

Pick:

Qty Part Number

Description

Batch

27.0" D2464

Neoprene Seal

39669

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3276-3

Decal

B36633

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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## Process Sheet

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Drawing Name: BAFFLE ASSEMBLY

Job Number: 44125

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3276

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST179

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

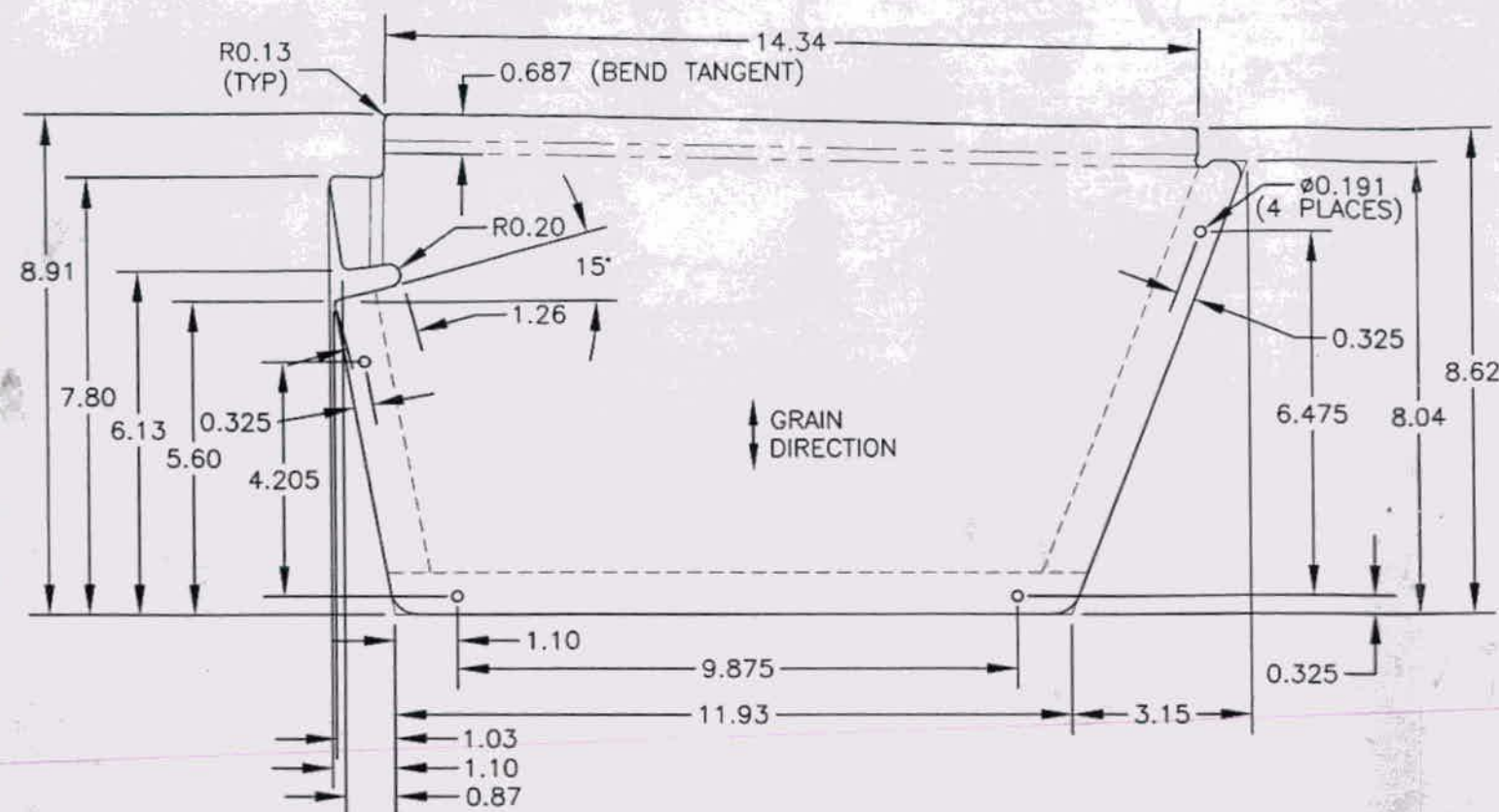
**NOTE:** Date & initial all entries





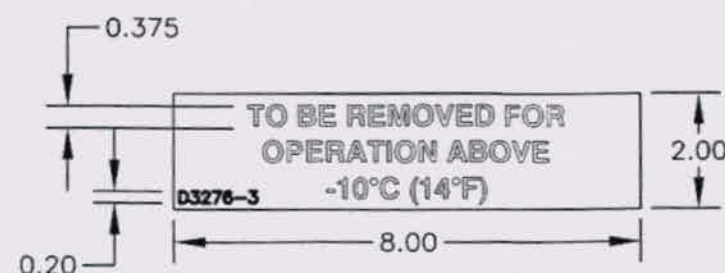






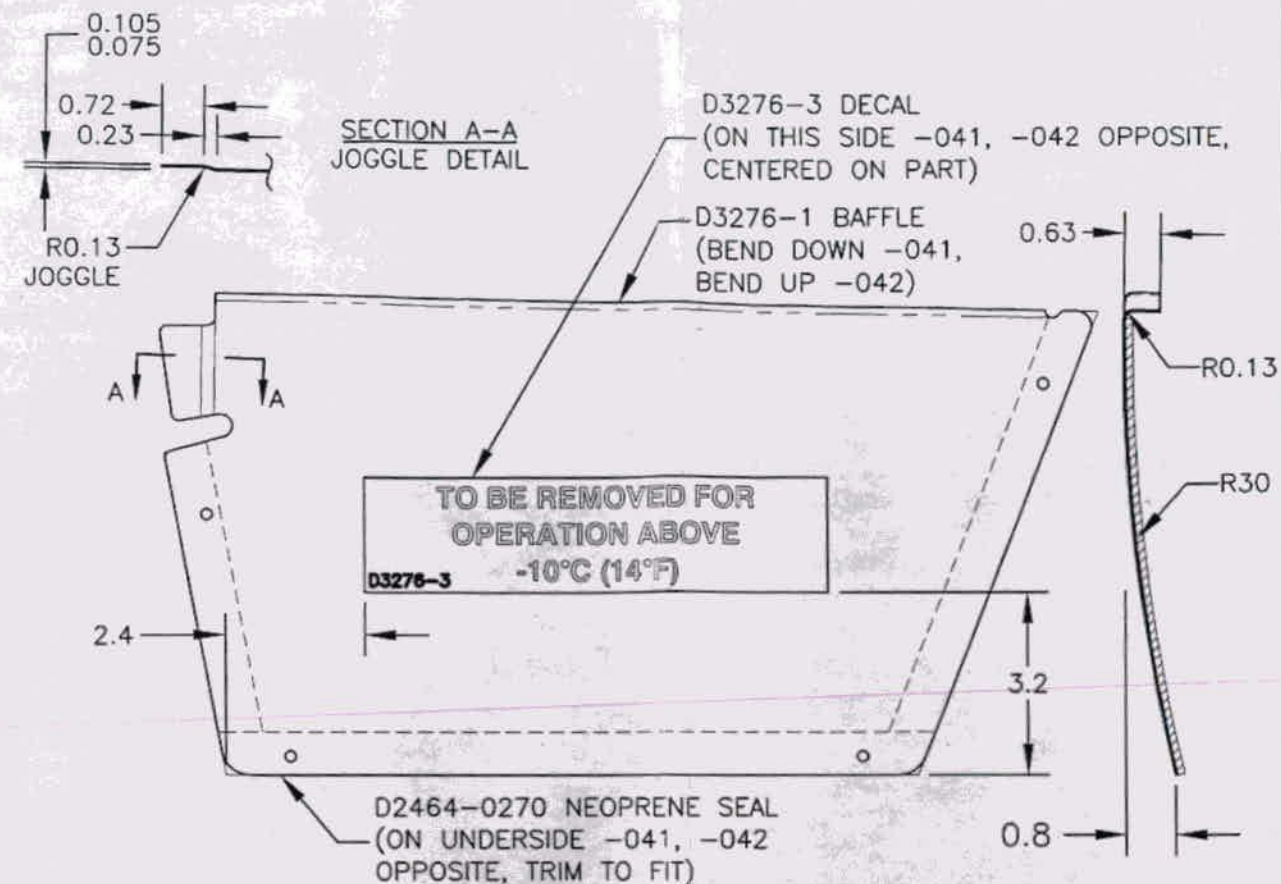
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED  
05.01.25

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 144125

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DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	✓	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D3276
		REV. B
		SHEET 1 OF 1
		SCALE 1:3



